

Work Order ID 63715

Wednesday, November 10, 2010 1:34:17 PM



Lid for eng.

Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	11/10/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	11/17/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	<i>10-11-10</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3914	B								

100 Weld per dwg A/R S.S. rod Batch: *111585* 0.00
 Large Fab

Large Fab Memo 0.00

Large Fab
 1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 make sure to place mesh correctly on lid, check with label plate before tacking mesh

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00

Quality Control

Cpl 10.11.10
BE
10.12.01 *1* *φ*

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Item ID:	D3914-041	Accept		Setup	Start	
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Item Name:	Long Basket Lid Assembly (350)					
Start Date:	11/10/2010	Start Qty:	1.00	Cust Item ID:		
Required Date:	11/17/2010	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo Lid is for eng testing 10/12/01 (x)	0.00 - inspect to Rev B Dwg. 0.00							
130 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M112588 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 1:00 Oven Temperature: 320° Finish Time: 1:30	0.00 0.00							
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M115790 Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg	0.00							

1 BL 10-12-1.

=> M 10/12/01

1 Ø

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Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 11/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: *G-A*

0.00



Packaging

Memo

0.00

Packaging

*w/o
64194*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*MF
10-12-01*

Picklist Print

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Work Order ID: 63715

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 11/10/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	43.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>43</div> <div></div> </div>													
<div> <div>61953</div> <div>20</div> <div></div> </div>													
<div> <div>63493</div> <div>23</div> <div></div> </div>													
D2728-3 Dart Logo label		Manufactured	No			140	Each	0.0000	1	1			
<div> <div>M115050</div> <div></div> <div></div> </div>													
D3914-1 Rib		Manufactured	No			100	Each	2.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div></div> </div>													
<div> <div>60703</div> <div>2</div> <div></div> </div>													
D3914-7 Rib		Manufactured	No			100	Each	2.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>WA</div> <div>2</div> <div></div> </div>													
<div> <div>60676</div> <div>2</div> <div></div> </div>													

Cpl 10.11.16

2
10112101

Cpl 10.11.16

B63716 → 2

Cpl 10.11.16

B63717 → 2

Picklist Print

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Work Order ID: 63715

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 11/10/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each

10.0000

3

3



Hinge Half, Lid

Location

Loc Qty

Loc Code

ST116

4

60723

4

WA

6

63256

6



Cpl 10-11-16

③

✓ D4018-5 Manufactured No

100 Each

6.0000

9

9



Rib

Location

Loc Qty

Loc Code

WA

6

59929

6



Cpl 10-11-16

B63718 → ⑨

✓ D4020-5 Manufactured No

100 Each

2.0000

1

1



Mesh (350 Basket Long, Lid)

Location

Loc Qty

Loc Code

WA

2

60643

1

60733

1



Cpl 10-11-16

B63719

✓ D4021-3 Manufactured No

100 Each

3.0000

1

1



Data Plate

Location

Loc Qty

Loc Code

WA

3

56050

1

60734

2



Cpl 10-11-16

①

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Shop Packet Print

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Picklist Print

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Work Order ID: 63715

Parent Item: D3914-041

Parent Item Name: Lc..g Basket Lid Assembly (350)



Start Date: 11/10/2010

Required Date: 11/17/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041 Manufactured No

100

Each

2.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



Ppl 10.11.16

Location

Loc Qty

Loc Code

WA

2

61066

2

B63720 → ①

✓ D4035-043 Manufactured No

100

Each

2.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



Ppl 10.11.16

Location

Loc Qty

Loc Code

WA

2

61067

2

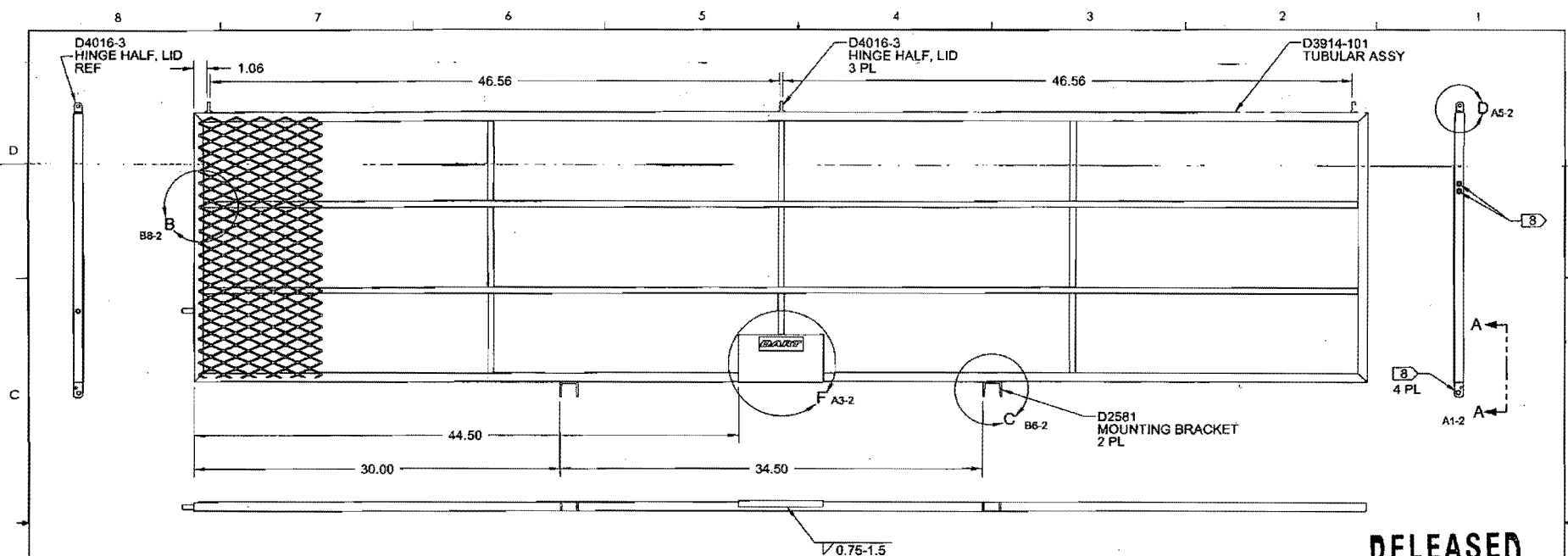
B63721 → ①

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH; 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

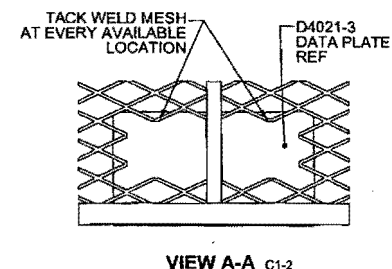
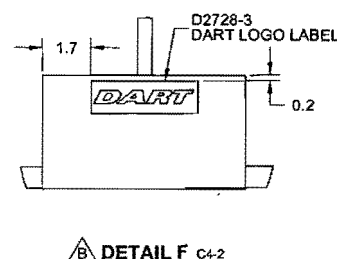
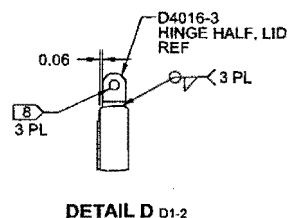
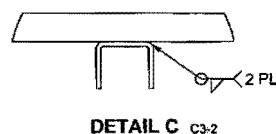
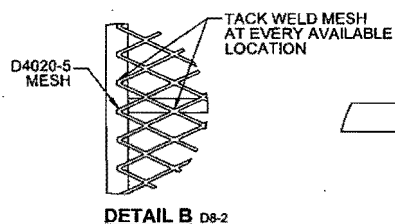
RELEASED
10.08.17 GP
ECN 10-546

REV.	DESCRIPTION	BY	DATE
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	LONG BASKET LID ASSY (350)	NTS
DE APPR.	SC	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	10.08.05		



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.05



NOTES:

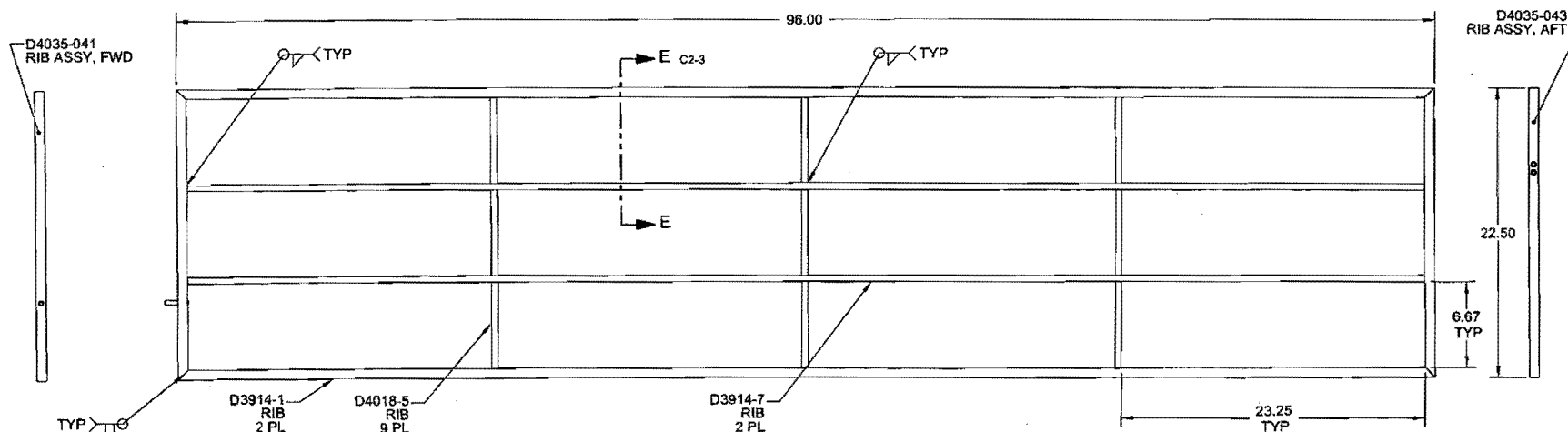
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED		D3914	SHEET 2 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET LID ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR DISCLOSED OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10.08.12 CP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	TC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO.	REV. B
MFG. APPR.	MD	D3914	SHEET 3 OF 4
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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